

Work Order ID 78598

78598

Page 1

January-11-12 2:44:23 PM

Item ID: D6101-001 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Billet
 Start Date: 11/01/2012 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6101	Rev B

100	PURCHASING	0.00
100		
Purchasing	Memo	0.00
Purchasing	Issue P/O: <u>15873</u>	
	a) Description: Alluminum billet	
	b) 6.00" x 6.250" x 2.00" thick	
	c) Tolerance on length are +0.030"/-0.000" \pm +/-0.008"	
	d) Grain direction along 6.00" length	
	e) Material: 7075-T7351 (QQ-A-250/12)	
	f) Material certification required	

CL 12/01/12 60

110	Receive & Inspect for Damage & Mat'l Certs	0.00
110		
Packaging	Memo	0.00
Packaging	Ensure material certification is attached	

U/2/01/12 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Ensure Material certification comply to Dwg D	0.00 0.00				60			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>NATU</u> Memo	0.00 0.00				60			
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

pl 12-01-23
(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-11-12 2:44:27 PM

Page 1

Work Order ID: 78598

78598

Parent Item: D6101-001

D6101-001

Parent Item Name: Saddle Billet

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP B: 01.05.04New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001P		Purchased	No			110	Each	0.0000	1	60			
D6101-001P									**				
7075-T7351 2X6X6.25													

11/24/12 (60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

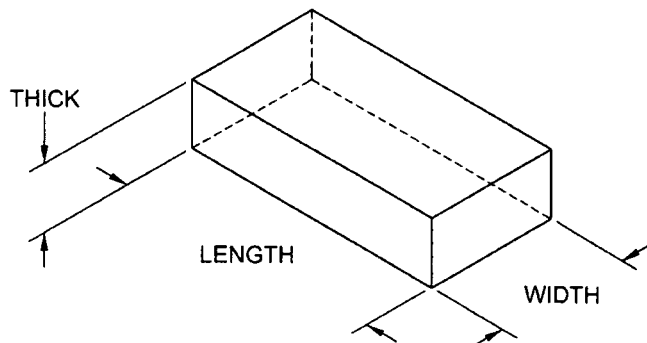
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



SHC
 RE
 ENGR
 UNCONTROLLED COPY
 SUBJECT TO
 WITHIN
 WORK
 NO. 785918 H.C.5
 12/01/11

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 9.700 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WB

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15873**

Purchase Order Date 1/12/12

PO Print Date 1/12/12

Page Number 1 of 1

Order From :

VC-COP001

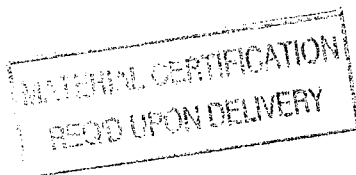
THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27546/PO BOX 4275, POSTAL "A"
TORONTO, ON M5W 5V8
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Requisition Nbr	
Vendor Fax	905 738 9033	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 1/12/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6101-001P	7075-T7351 2X6X6.25	1/18/12 Yes	60.00 Each	Yours ppd	\$31.4900	\$1,889.40
Special Inst: AS PER DWG D6101 REV. B B78598 MATERIAL: 7075-T7351 AS PER QQ-A- 250/11 SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6" LENGTH TOLERANCE ON LENGTH ARE +0.030"/- 0.000"							
2	D6101-003P	7075-T7351 2X6.25X7.875	1/18/12 Yes	60.00 Each	Yours ppd	\$41.3500	\$2,481.00
Special Inst: AS PER DWG D6101 REV. B B78599 MATERIAL: 7075-T7351 AS PER QQ-A- 250/11 SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGTH TOLERANCE ON LENGTH ARE +0.030"/- 0.000"							



PO Total: **\$4,370.40**

Change Nbr: 1

Change Date: 1/12/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

B I L L O F L A D I N G
 Ship From:
 THYSSENKRUPP MATERIALS NA
 2821 LANGSTAFF ROAD
 CONCORD, ONTARIO L4K 5C6
 Tel: 905 669 9444 Fax: 9057389033

No: PEC 748402
 Ship Date 20Jan12 at 12:24 From PFW
 Probill
 Via VIM TRANSFER
 FOB CONCORD
 Frt PREPAID
 Route 0- 0 Manifest
 Vhcle Trailer
 Slp STAN IVERS (905-534-1350)
 Sold To: (20115)
 DART AEROSPACE
 1270 ABERDEEN ST
 HAWKESBURY, ON K6A 1K7

Ship To: (1)
 DART AEROSPACE
 1270 ABERDEEN ST
 HAWKESBURY, ON K6A 1K7
 Tel: 613-632-9577 Fax: 613-632-1053

B I L L O F L A D I N G				
1) Our Order PEC-407898- 1 Your PO # 15873				
ALUMINUM PLATE 7075-T7351 USI				
2.00" THICK X 6.2500" X 6.0000"				
GRAIN DIRECT ON THE 6" DIM LENGTH				
Heat Number	Tag No	Quantity	PCS	Wt LBS
779581	28054	15.63 SFT	60	457

2) Our Order PEC-407898- 2 Your PO # 15873				
ALUMINUM PLATE 7075-T7351 USI				
2.00" THICK X 6.2500" X 7.8750"				
GRAIN DIRECT ALONG THE 7.875 LENGTH DIM				
Heat Number	Tag No	Quantity	PCS	Wt LBS
779581	28055	20.51 SFT	60	600

		Tags	PCS	LBS
TOTAL:		2	120	1057

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
 WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
 TO SHIPPING.
 ATTN: CHANTAL/LINDA
 ** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
 ** REFERENCED ON IT **

TOTAL 2 SKIDS G.W. 1107 LBS
 ITEM (1) SKID
 ITEM (2) SKID

Page: 1Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE
 RAPPORTÉES IMMÉDIATEMENT.
 ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
 RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
 MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1321437

0

Ship Date

B.L. No.

Invoice No.

Ship From:

RIVERDALE, IA.

2011-12-16

6583417

00000

Alcoa No. Item

1000349904-1

DP-49904-1

P.O. No./Govt Contract No.

Customer

Alcoa Item

5400120306

COPPER & BRASS SAL G041007178R11

Page 1 of 2

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DR
WALLINGFORD 06492 CT

Item Description

2.0 IN TK (+.055 -.055) X 48.5 IN W (+.3125 -
0.000) X 144.5 IN LN (+.5 -.0.0) (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED. AMS-QQ-A-250/12 IS 2007 EXC MRK AMS-STD-
2154 IS 2010 EXC MRK AMS4078 REV G EXC MRK
ASTMB209 REV 10 EXC MRK ASTMB594 REV 09 EXC MRK
BSS7055 REV A EXC MRK CMMPO25 REV S EXC MRK
MMS159 REV P EXC MRK PS21211 REV L
((MARKED)) KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 5000 LB QUAN TOL +/-
10 % USI CL A 3 MM CQR 0148581 REV 13 CUST REQ 11-12-
16 *** W/E 11-12-24 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	357510	779581	4273	3	PC	47310 47347

Notes for CQR: 0148581.13

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ- A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PROD UCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/12 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMME RSION - TYPE I.
THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMME RSION - TYPE I.
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIREMEN TS OF MIL-STD-2154.

CQR: 0148581.13 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max	68.9	
		Min	69.0	57.0
				6

T7351 Elec. Cond. (EC) % MIN 38.0 PCT

ThyssenKrupp Materials NA, Inc.

Copper and Brass Sales Div sold to:

CUSTOMER: ThyssenKrupp Materials NA-ECAD

YOUR PO#: PEC - 236099

CBS ORDER#: 1401047988

QTY: 60 PCS

BY: JJC

DATE: 1-16-12

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Malcolm Murphy
Director of Manufacturing Davenport Works

Terrence Thom
Quality Assurance Manager

1321437	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2011-12-16	6583417	00000	1000349904-1
P.O. No./Govt Contract No.	Customer	Alcoa Item	DP-49904-1
5400120306	COPPER & BRASS SAL G041007178R11		

Page 2 of 2

CQR: 0148581.13 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
		Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05
		Min			1.2		2.1	0.18	5.1		
Alloy 7075											
Lot: 779581	- Mechanical, Physical, Metallography, Quantometer Results										
Tmpr	Dir	No->	UTS	TYS	EL4D						
T7351	Long Transv.	Test	KSI	KSI	PCT						
		3	72.2	62	10.8						
			72.6	62.2	10.8						
			72.8	63	11.1						

T7351 Elect Cond %IACS 40.7 40.8 40.8 PCT

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9977033	Actuals	0.06	0.28	1.6	0.02	2.4	0.19	5.7	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

COPPER AND BRASS SALES

MATERIAL TYPE

ALUMINIUM ALLOYS

PRODUCT DESIGNATION

2014 2024 2224 2324 7050 7075 7150 7175 7475 ALUMEC 89 ALUMEC 99 QC-7

"WARNING"

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSION POTENTIAL MAY BE PRESENT WHEN: DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH CERTAIN METAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION-PROOF VENTILATION. KEEP MATERIAL DRY.

THIS PRODUCT CONTAINS BERYLLIUM AND COPPER. INHALING BERYLLIUM DUST OR FUMES MAY CAUSE CHRONIC BERYLLIUM DISEASE (CBD), A SERIOUS CHRONIC LUNG DISEASE IN SOME INDIVIDUALS. BERYLLIUM IS A CANCER HAZARD; OVER TIME CBD AND CANCER CAN BE FATAL. TARGET ORGAN IS PRIMARILY THE LUNG. INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN, TEETH, AND HAIR DISCOLORATION. CHRONIC OVEREXPOSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE, SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES. TARGET ORGAN IS PRIMARILY THE LUNG, BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER. CHRONIC OVEREXPOSURE TO IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS. CHRONIC OVEREXPOSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS. OVEREXPOSURE TO AMORPHOUS SILICA CAN CAUSE DRYING OF THE MUCOUS MEMBRANES OF THE EYES, NOSE, AND THROAT.

THIS PRODUCT ALSO CONTAINS NICKEL AND CHROMIUM COMPOUNDS. INHALATION OF NICKEL DUST OR FUME MAY RESULT IN INFLAMMATION OF THE RESPIRATORY TRACT AND CAUSE NASAL AND/OR LUNG CANCER. NICKEL HAS BEEN IDENTIFIED AS A POTENTIAL HUMAN CARCINOGEN. EXPOSURE TO CHROMIUM DUST OR FUMES MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND LIVER DAMAGE. UNDER HIGH TEMPERATURES, HEXAVALENT CHROMIUM MAY BE PRODUCED, IF IN THE INSOLUBLE FORM, IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65).

IF COATED WITH OIL, MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.

READ THE ALUMINIUM/ALUMINIUM ALLOYS MATERIAL SAFETY DATA SHEET (MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL.

* If processing or recycling produces particulate, use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding, grinding, abrasive sawing, sanding and polishing. Any activity which abrades the surface of this material can generate airborne particulate. Use appropriate NIOSH approved respiratory protection (P95; P100 for lead with, quantitative fit testing required) if exposures exceed the permissible limits.

* The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.

* Aluminum, in solid form and as contained in finished products presents no special health risk.

* Sold for manufacturing purposes only. This product can be recycled; contact your sales representative.

For additional information, call or write to Copper and Brass Sales, 22355 West Eleven Mile Road, Southfield, MI 48033, telephone 248-233-5600, or visit our web site @ www.copperandbrass.com.

ALUMINUM LABEL NO. 300-1056

ISSUED 10/01/2008